

Date: Tuesday, 21/10/2008 10:45:15 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350 SKIDTUBE ASSEMBLY LH
Job Number :	42765		
Estimate Number :	10262		
P.O. Number :		Part Number :	D350636011
This Issue :	21/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2750 REV F
First Issue :	1/1	Project Number :	N/A
Previous Run :	42764	Drawing Revision :	F
Written By :		Material :	
Checked & Approved By :	JLD 08.10.21	Due Date :	10/11/2008
Comment :	Est Rev:I 02.09.25 Rearranged procedure steps KJ Est Rev:J 06-03-23 As per Rev D JLM Est Rev:K 06-07.13 As per dsi9343 EC Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC Est Rev:M 08-04-22 update steps 4, 13 DD verified by:EC Est Rev:N 08-09-23 revF as per dwg DD verified by:ec		
Additional Product			

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.11.04

**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

08/11/05

2.0	D26003BENT	Extrusion Bent
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

42342 SL8-10-26

3.0	D2744	Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

33242

BE 8-10-27

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: D350636011

Job Number:



Seq. #: Machine Or Operation: Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *m/09213 BE 08/10/27*

10-Grind welds flush as per Dwg D2750 *AWM*

12- Scribe batch# inside per dwg D2750 *8-10-28*

SL8-10-26

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/29 (X)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/29 (X)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

D M 8-10-29

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DD 8-10-29

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Job Number: 42765

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D2739	350 I Beam
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch:

BC12943

DH 8-12-29

10.0	D34901	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

842780

BE 8-10-30

11.0	D34903	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch:

842186

BE 8-10-30

12.0	D2743	Crossbolt Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch:

841113

BE 8-10-30

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

M
8-12-29

W/O:		WORK ORDER CHANGES						
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Job Number: 42765

Part Number: D350636011

Job Number:



Seq. #: Machine Or Operation: Description :

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch:

exp. date:

M109449

8-11-7

M7-10-29

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R

Aluminum Rod

batch:

M109213

BE 8-10-30

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

RT
08-10-30

11-Debur holes

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/31 (X0)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/31 (X0)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-H 08/11/03

17.0

POWDER COATING

POWDER COATING



M109152



(TX)

Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30
320°F
4:00

M-H 08/11/03

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08-11-04

(X1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 42765

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	ALS41032225	Insert
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: M1100621

HL

20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1- Install inserts as per Dwg D2750

HL

08-11-04

(XD)

21.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B40726

HL

22.0	D37911	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B342418

HL

23.0	D37931	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B342639

HL

24.0	D37933	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B342247

HL

25.0	D37941	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B342480

HL

08-10-04

(XD)

W/O:		WORK ORDER CHANGES						
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Job Number: 42765

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: 1343116

JS

27.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1341633

JS

28.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1342234

JS

29.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: 1342235

JS

30.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: 1341141

JS

31.0

D3488041

Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: 1336234

JS

32.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

O-RING

NAS1611-010 batch: _____

(or MS28775-010) batch: _____

W/A

W/O:		WORK ORDER CHANGES						
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Job Number: 42765

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
O-RING
batch:

N/A u

34.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PLUG ASSEMBLY
Batch: 1342637

HL

35.0

D3492043

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
PLUG ASSEMBLY
Batch: 1342183

HL

36.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)
Bolt
Batch: 11109752

HL

37.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: 11108880

HL

38.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT
Batch: 11109765

HL

39.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT
Batch: 11106896

HL

68-11-04 *(K)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 42765

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	AN960C10L	washer
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Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)
washer
Batch: M109545 *JS*

41.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WASHER
Batch: M108928 *JS*

42.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
NUT
Batch: M109249 *JS*

43.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
NUT
Batch: M109545 *JS*

44.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
WASHER
Batch: M108964 *JS*

45.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: M1107912

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241

BATCH: M1109449
EXP DATE: 08/11

JS 08-11-04 *JS*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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QA: N/C Closed: _____ Date: _____

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Job Number: 42765

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-assemble o'ring as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: _____

ulr 5/6/04

5-Coat all exposed fasteners with "LPS Procyon" batch: _____

M104251

08-11-05

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/6/04

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 1540724

SD

49.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109092

SD

50.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M109032

SD

51.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108964

8/11/5

(14)

SD

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Job Number: 42765

Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M109740

50

53.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B340829

50

54.0

D35321

Spacer



Comment: Qty.: 2.0000 (s)/Unit Total : 2.0000 (s)

batch: B42350

8/11/5

(K)

50

55.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Soskulas

56.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-011

Loc na

2/1/5

(R)

50

57.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/06

Job Completion



mr 08-11-05

B42765

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

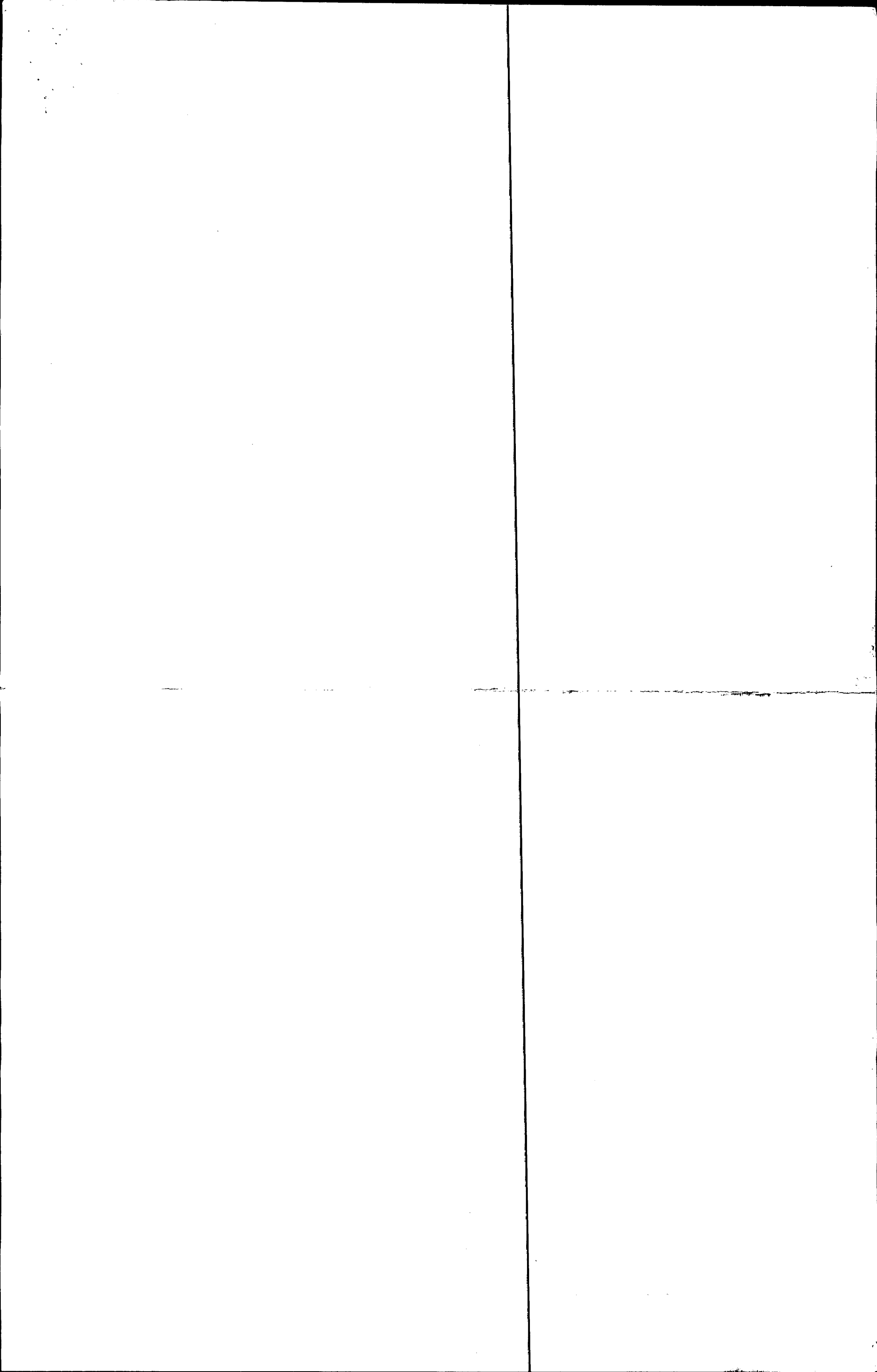
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCK 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		
DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2750 REV. F SHEET 1 OF 11 TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



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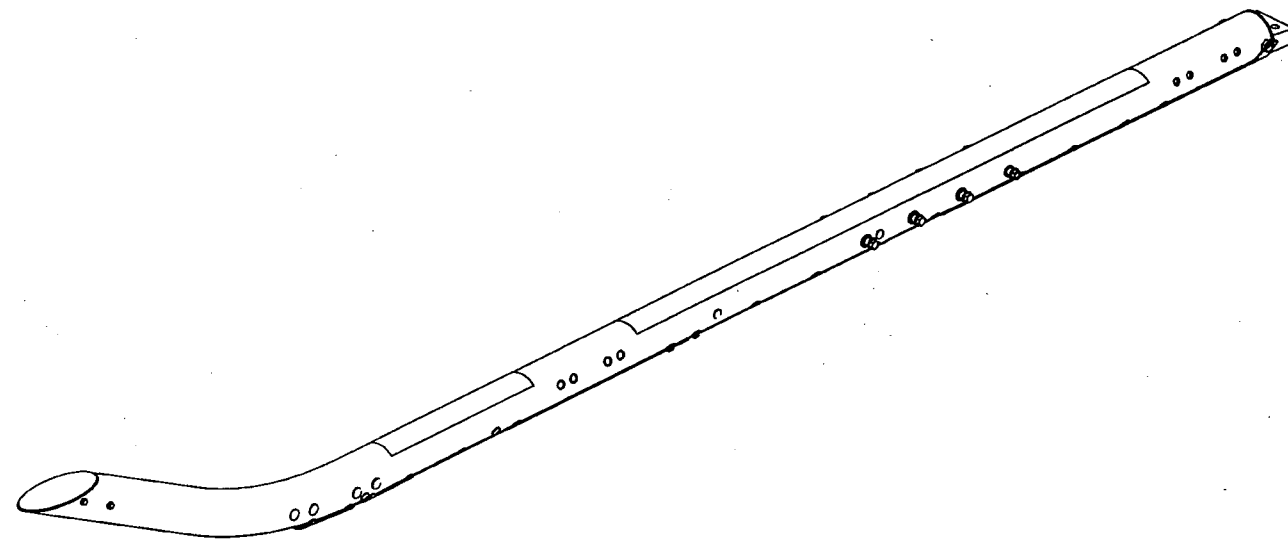
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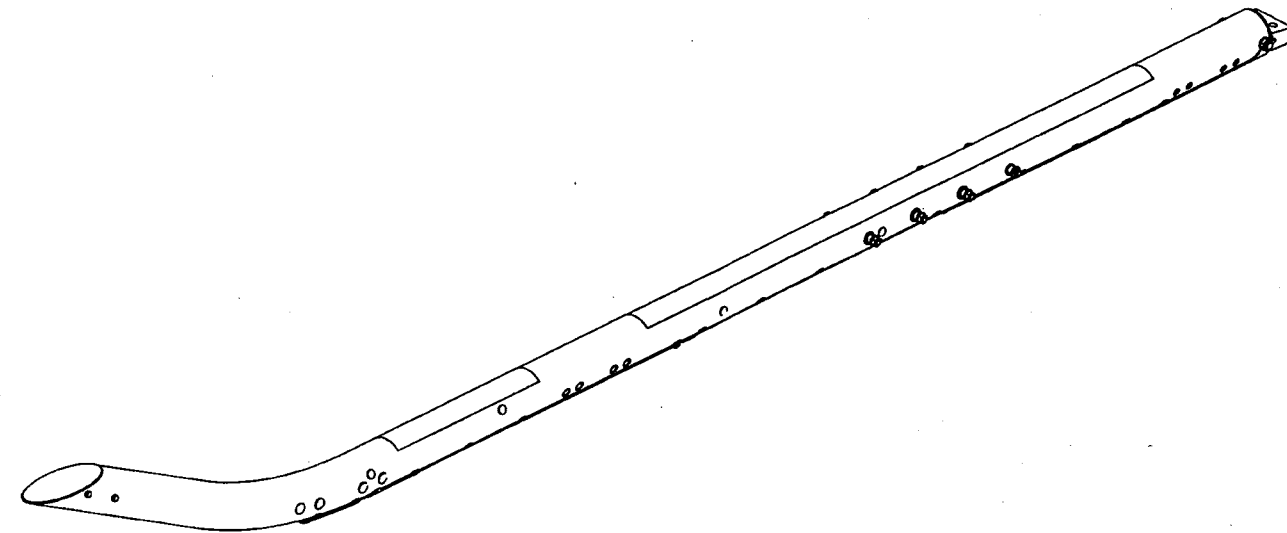
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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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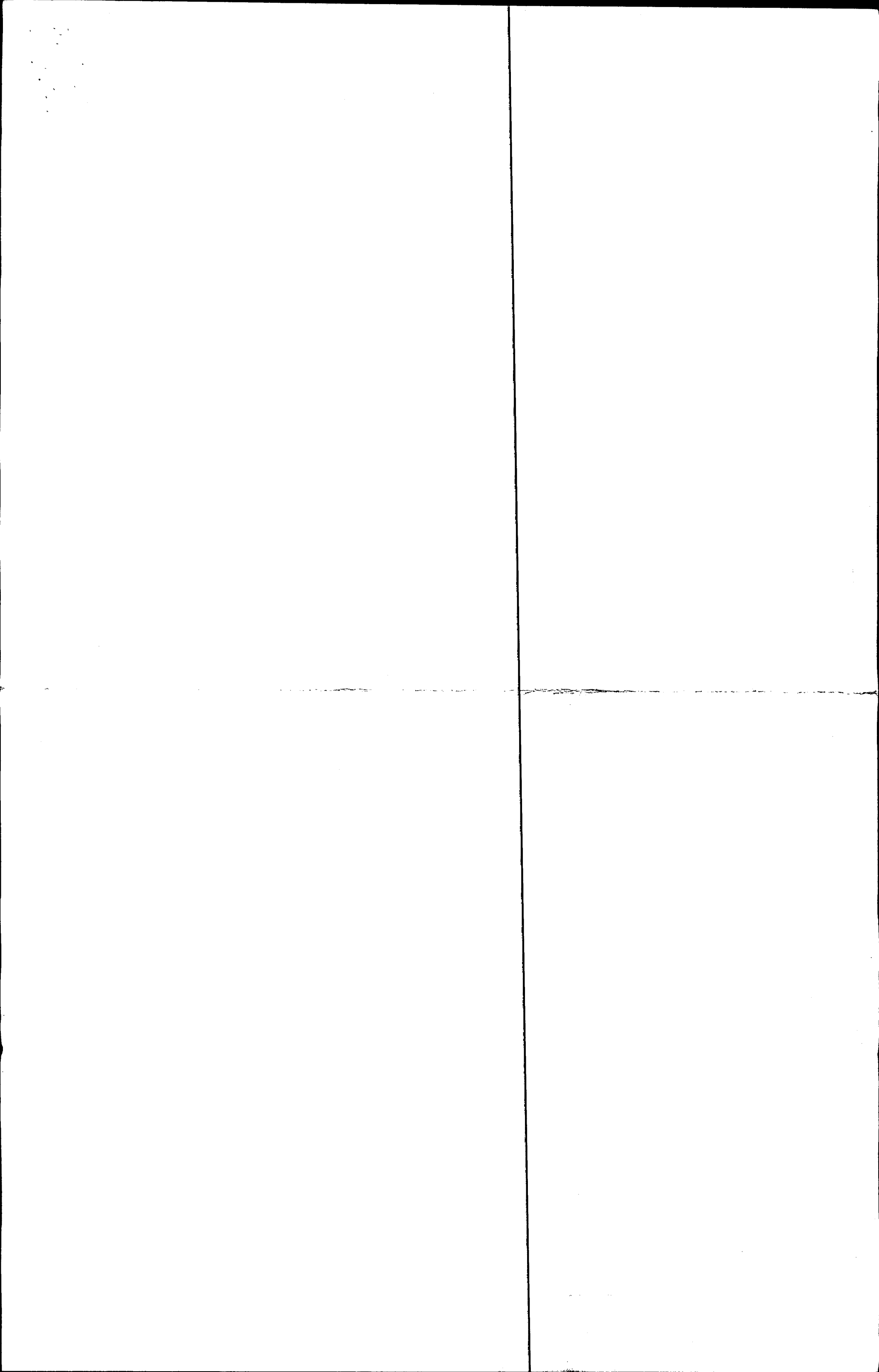
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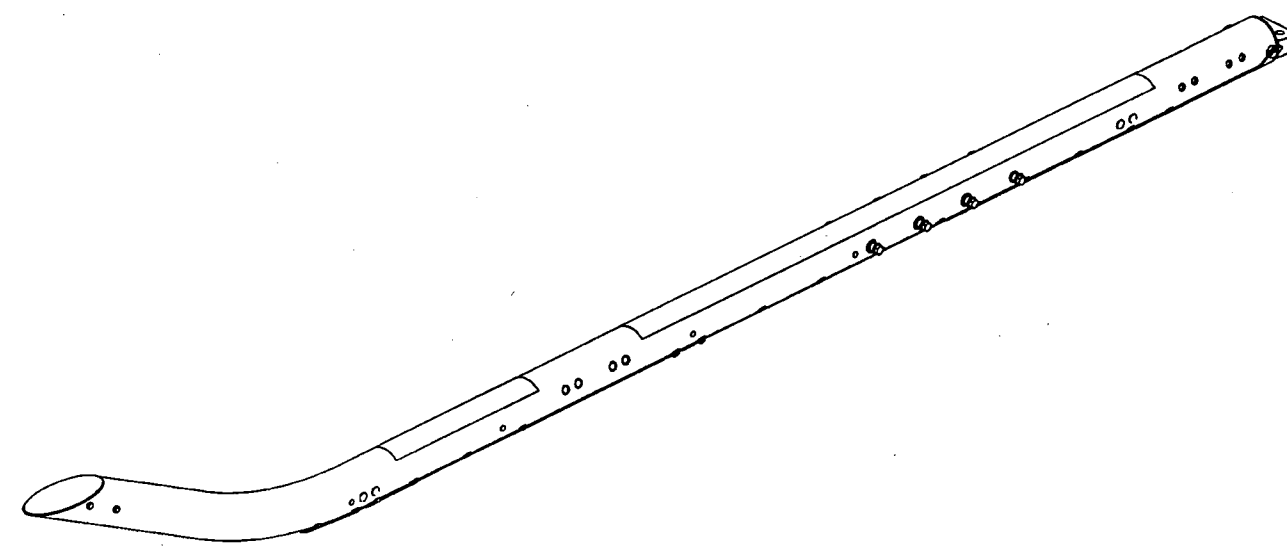
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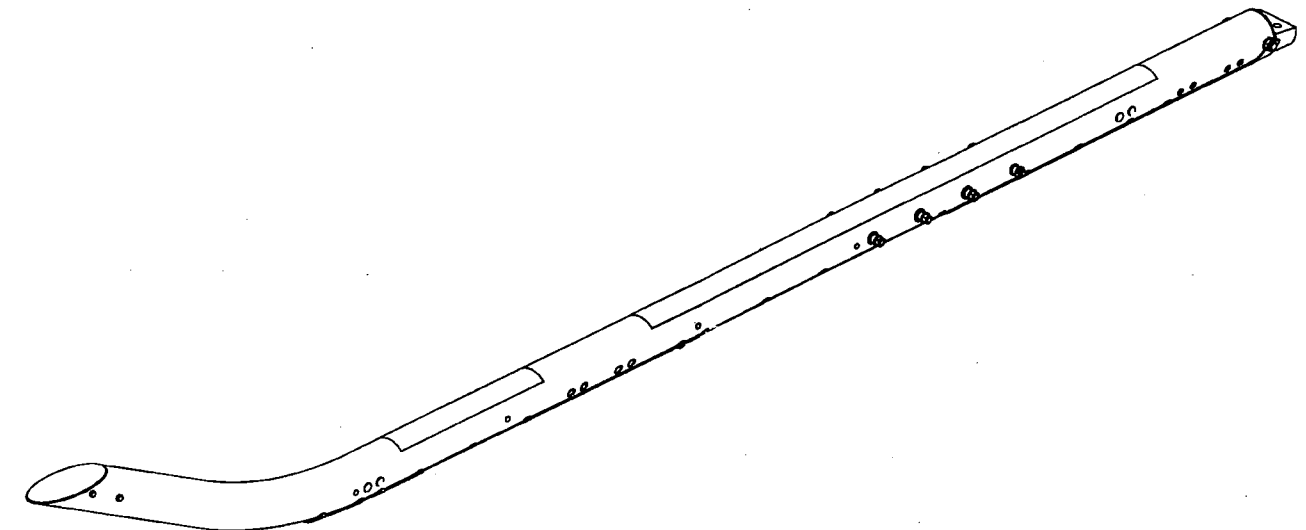
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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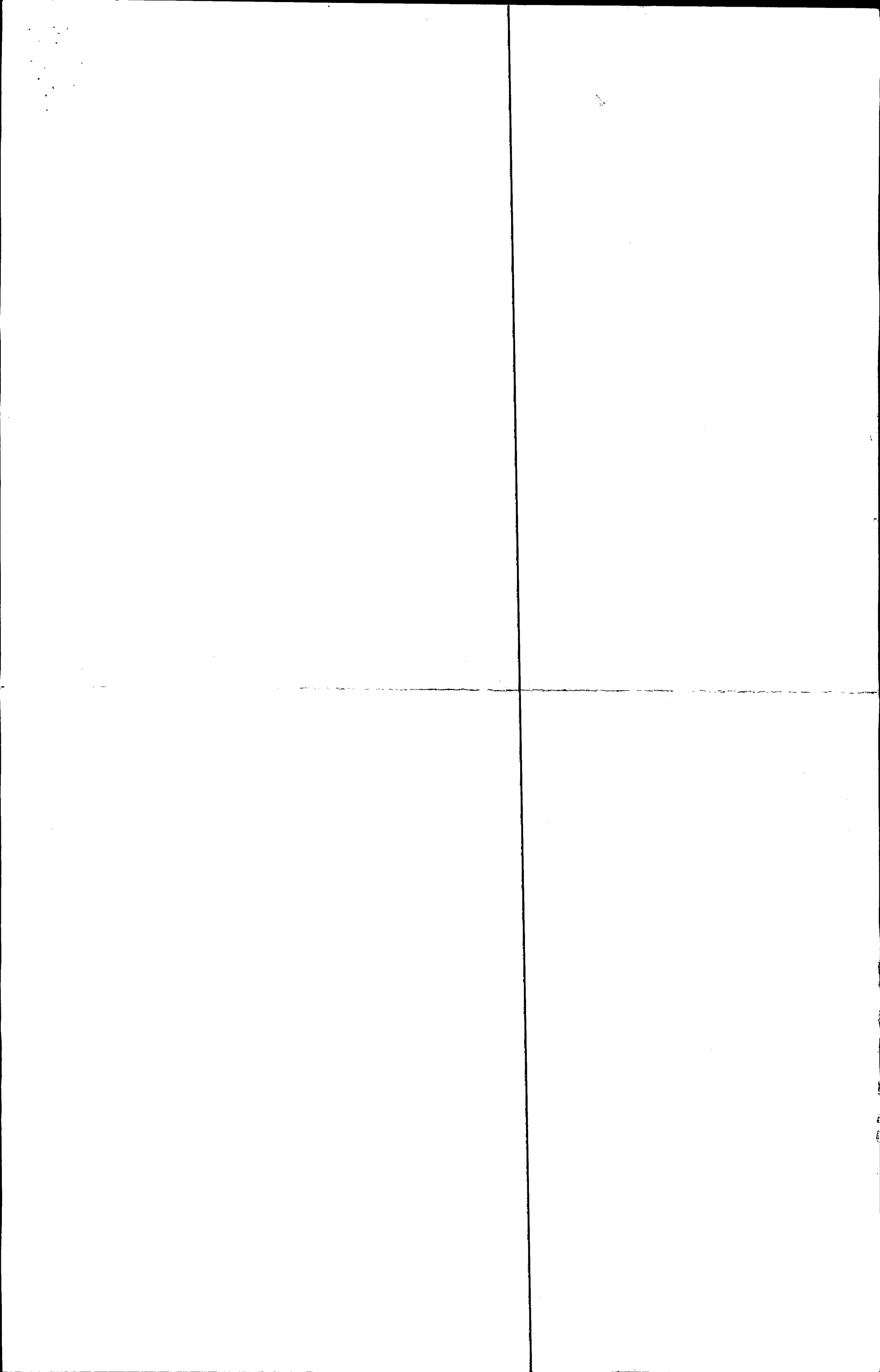
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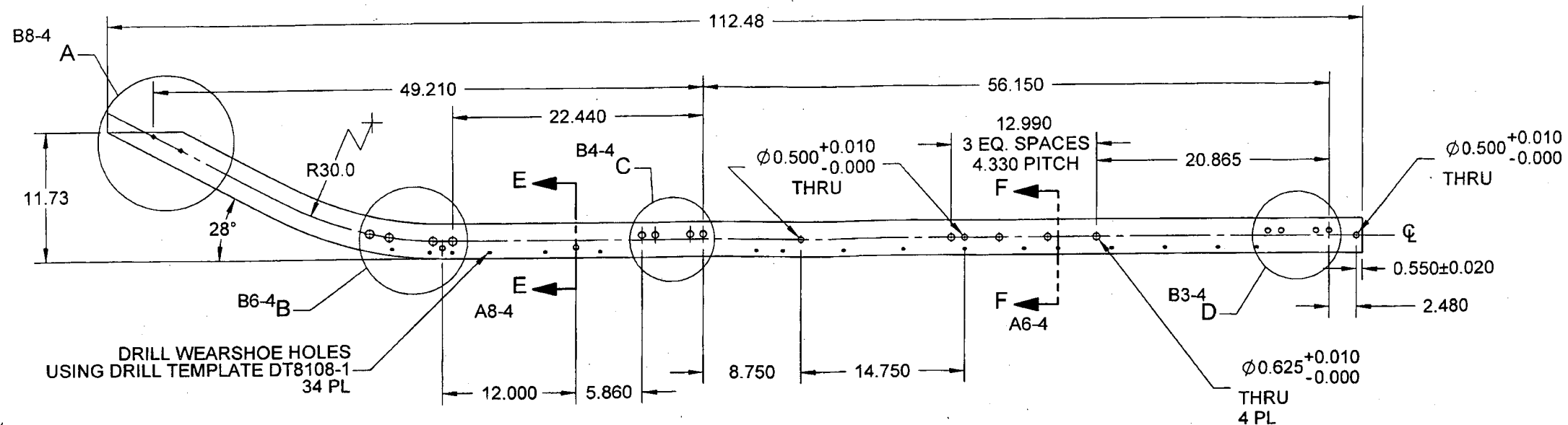
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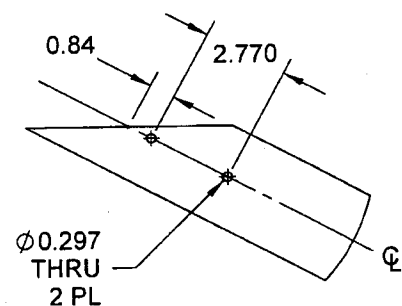
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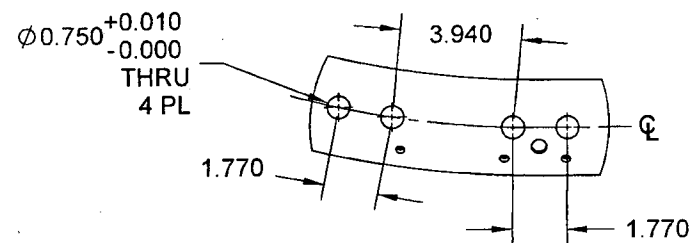
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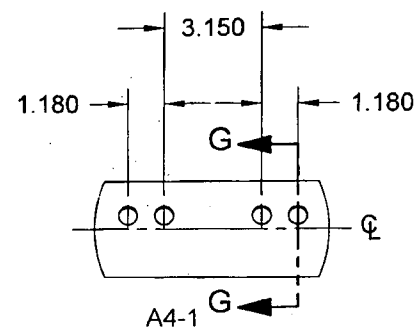
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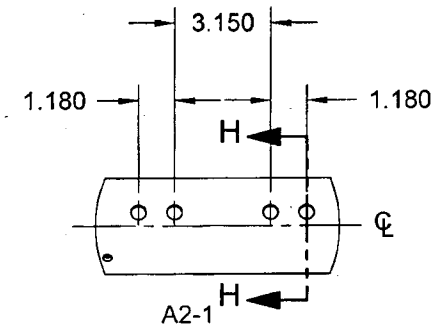
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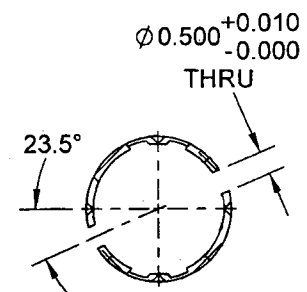
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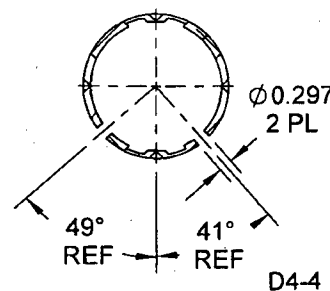
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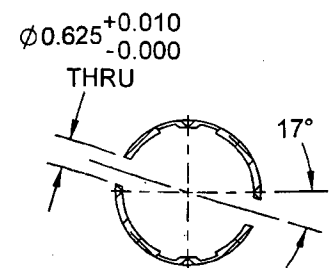
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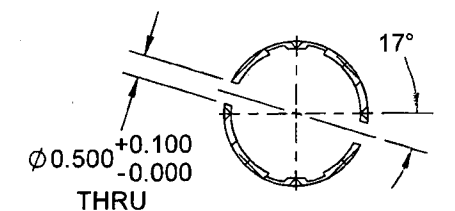
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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8 7 6 5 4 3 2 1

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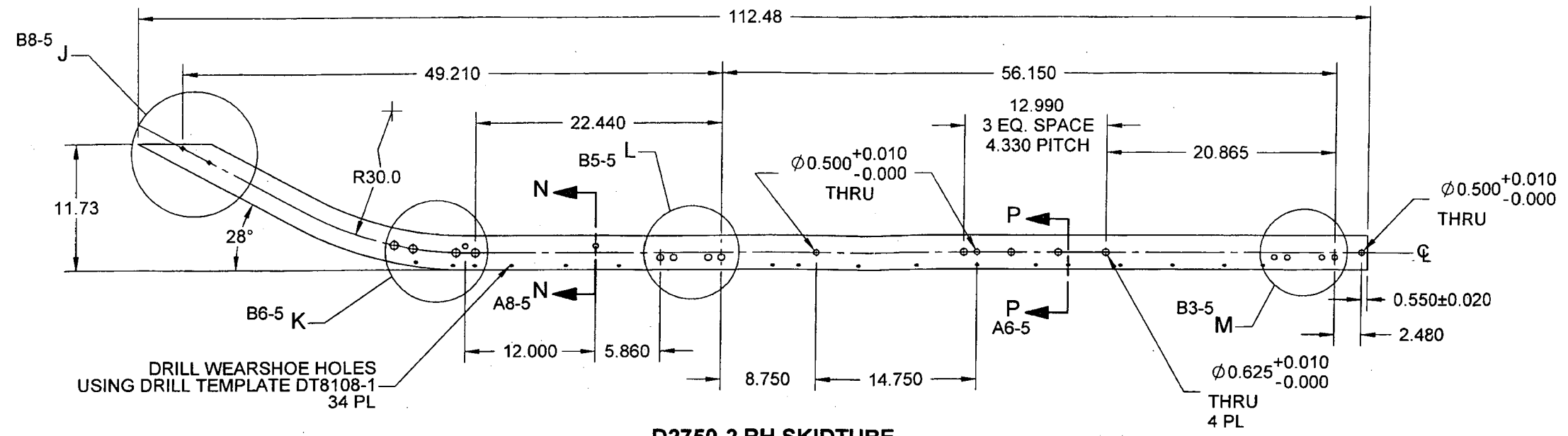
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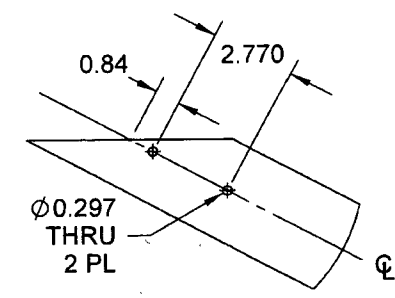
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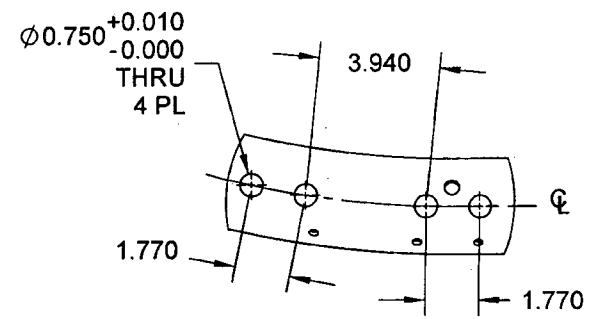
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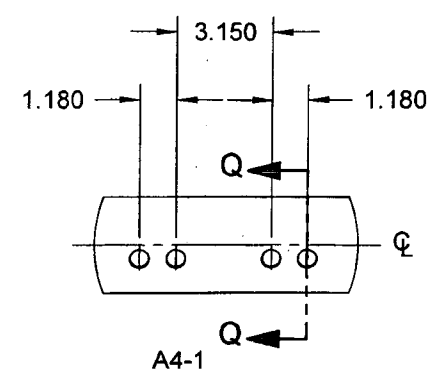
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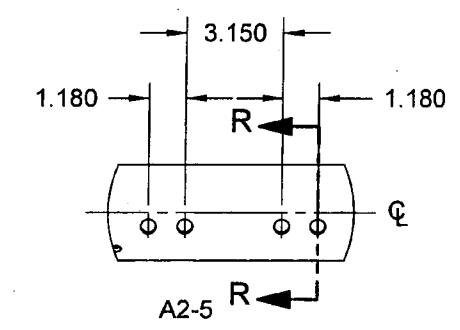
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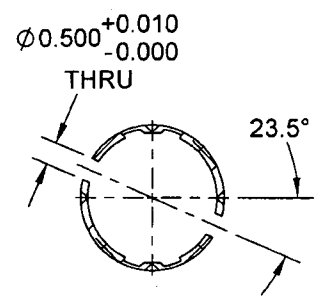
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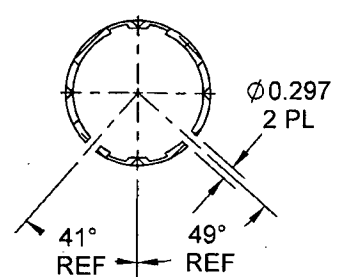
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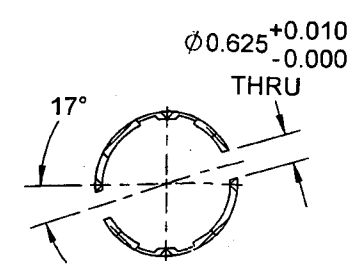
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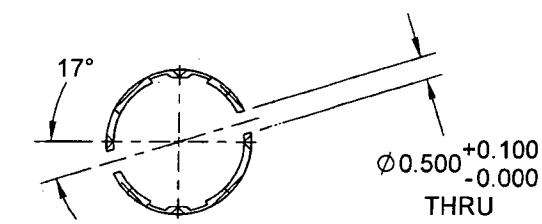
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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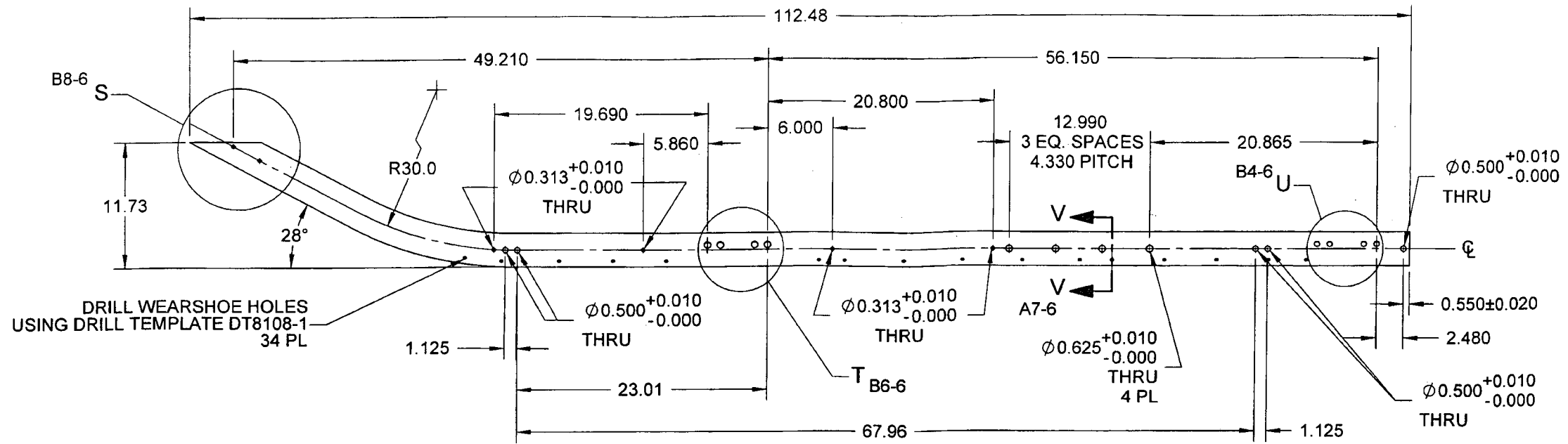
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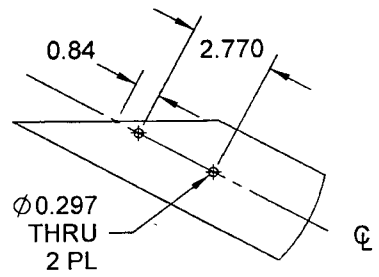
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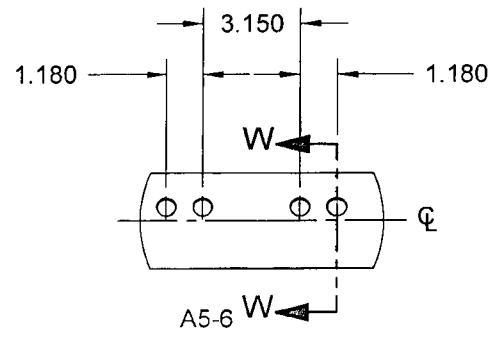
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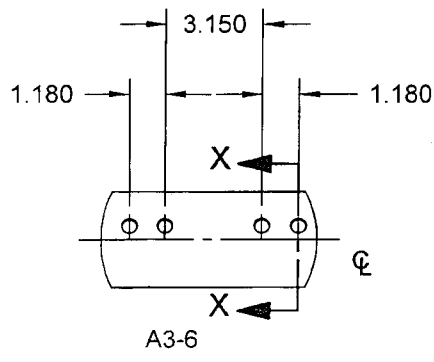
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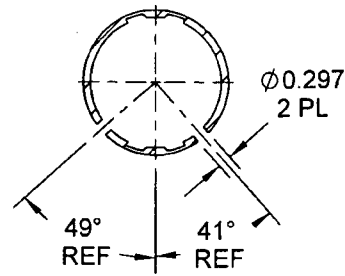


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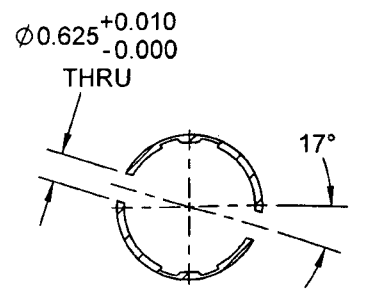


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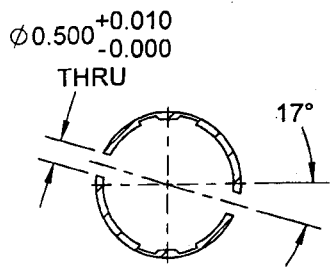
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

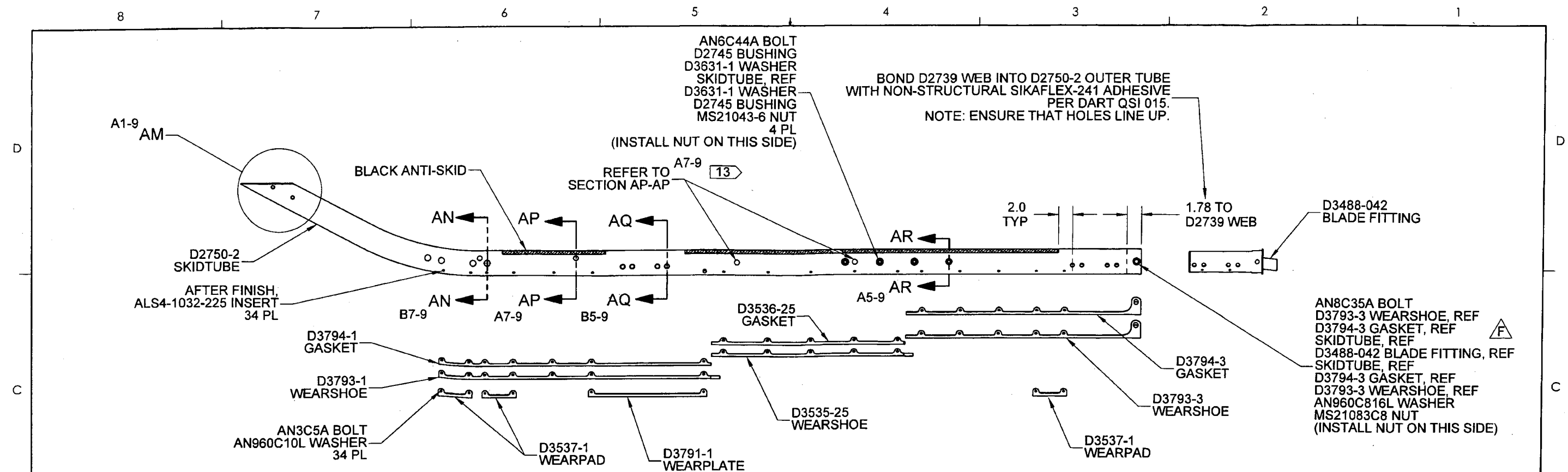
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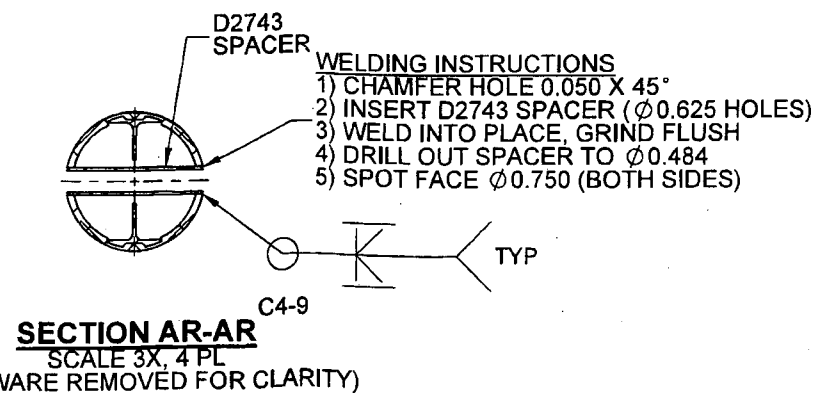
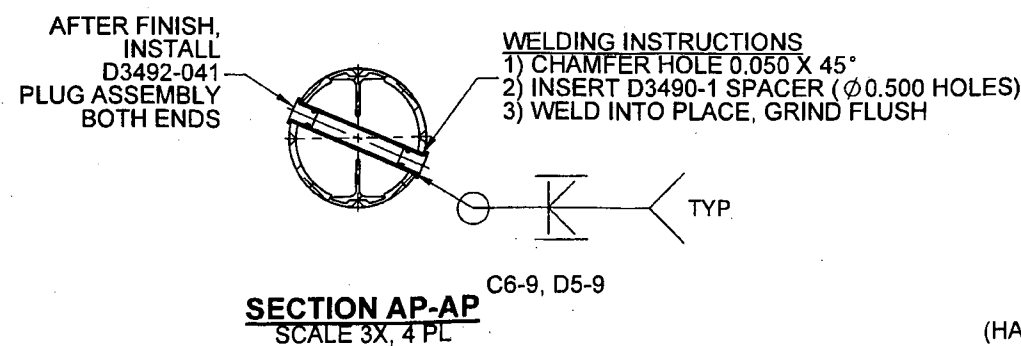
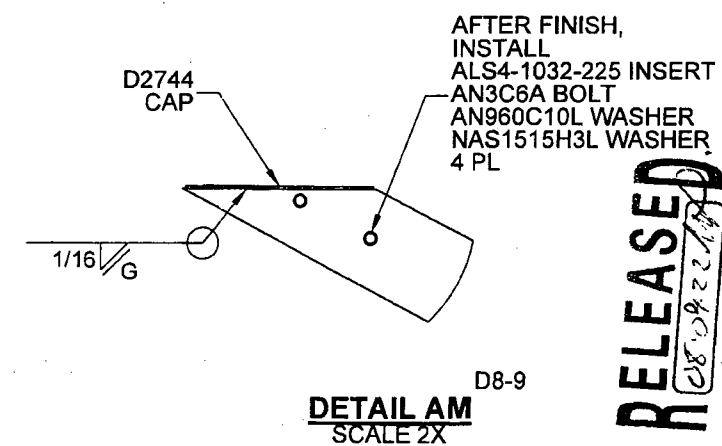
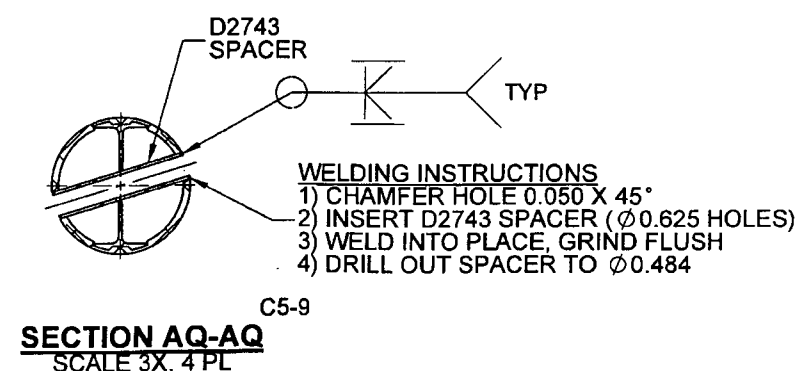
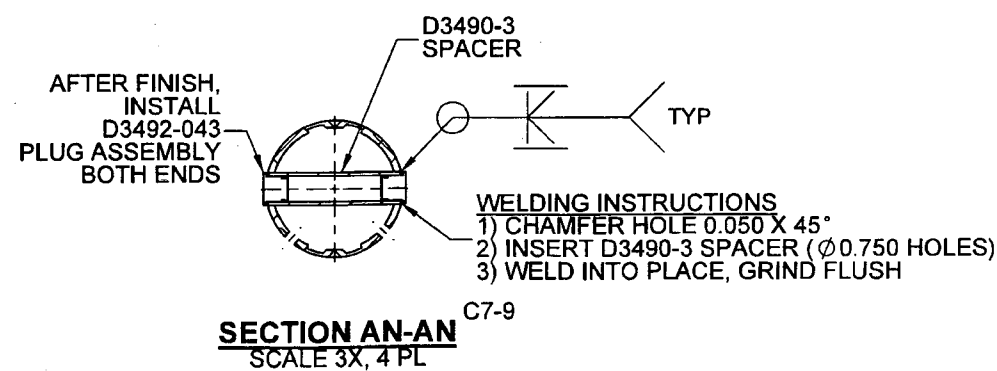
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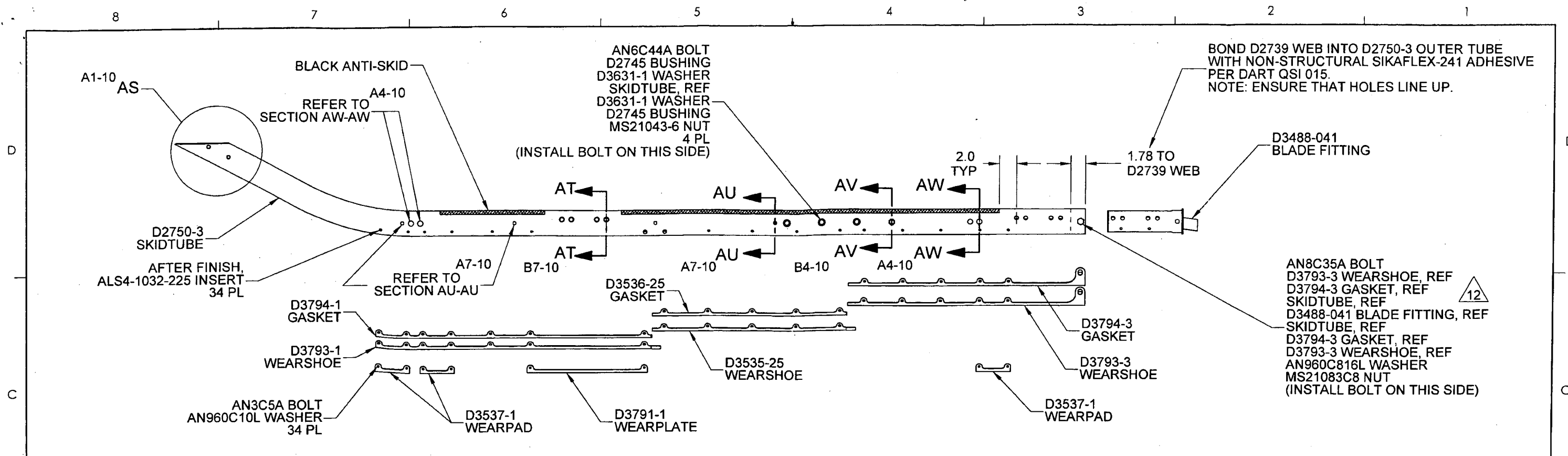
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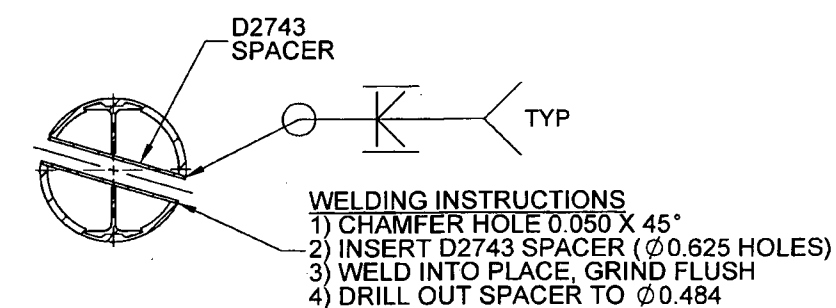
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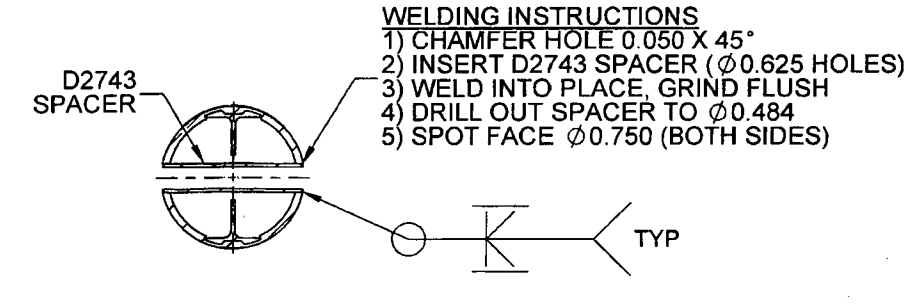
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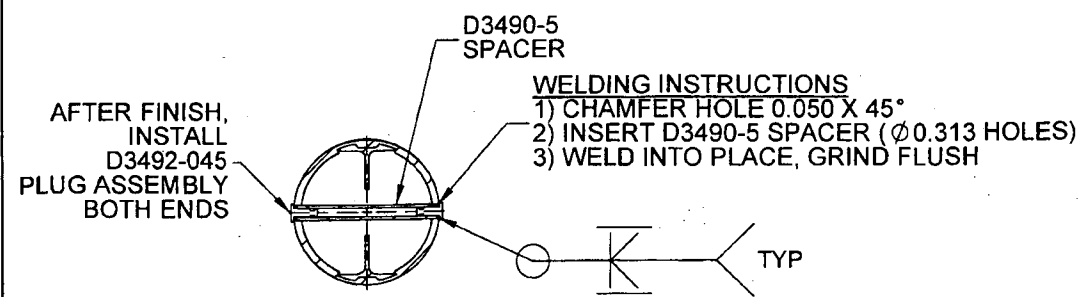
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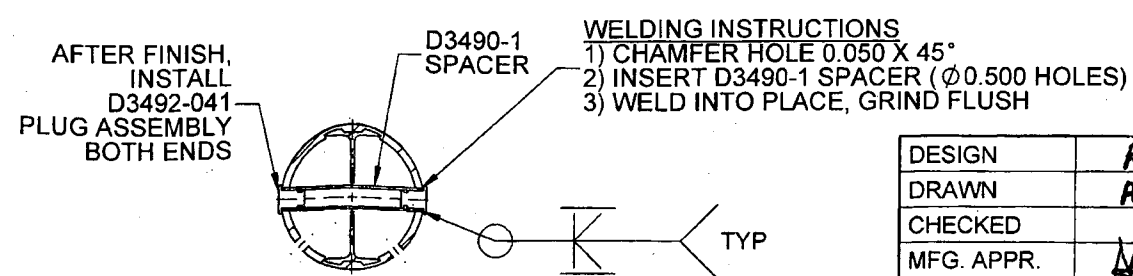
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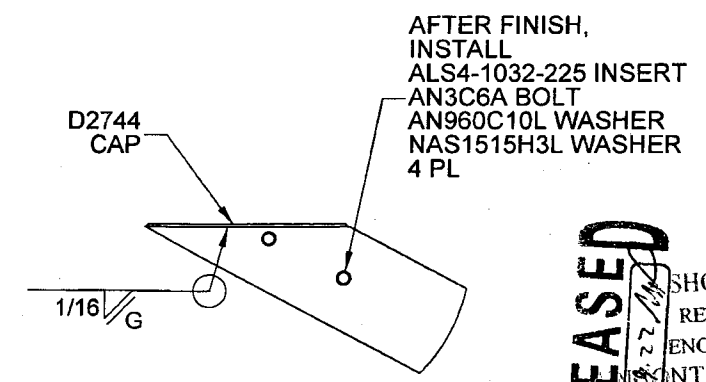
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SECTION AU-AU
SCALE 3X, 4 PL



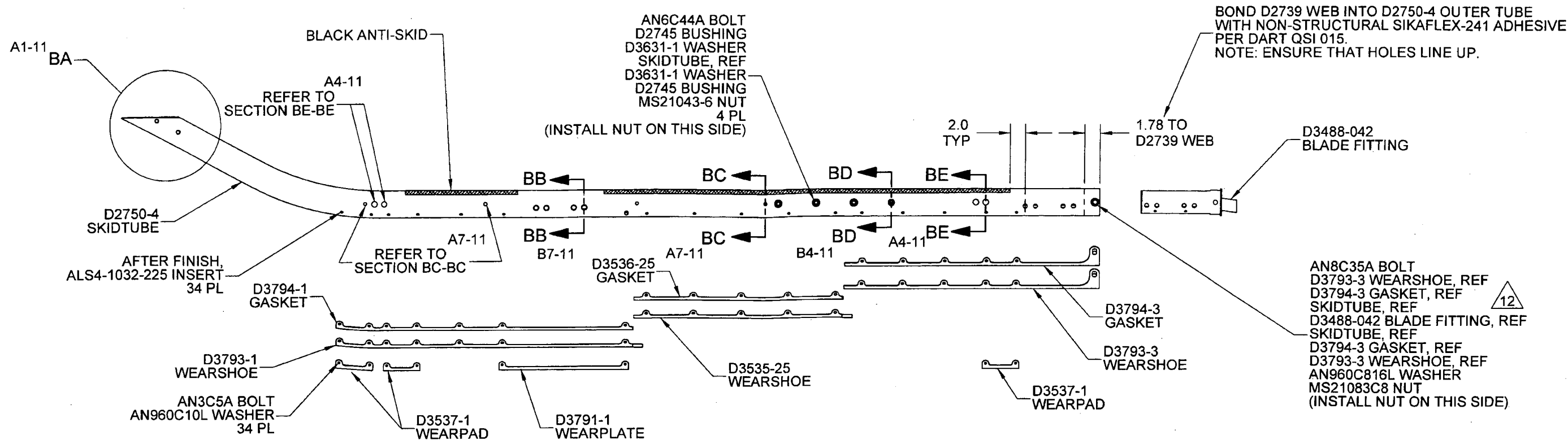
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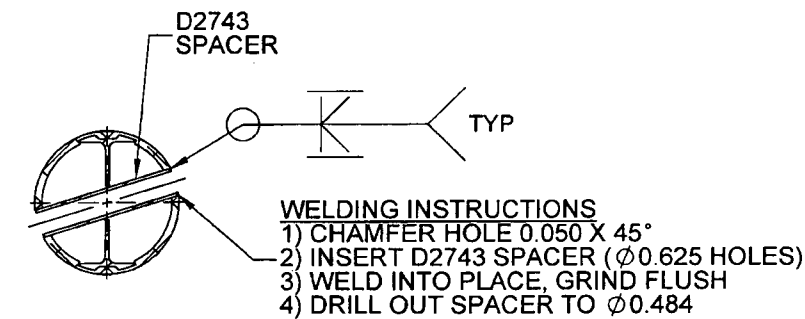
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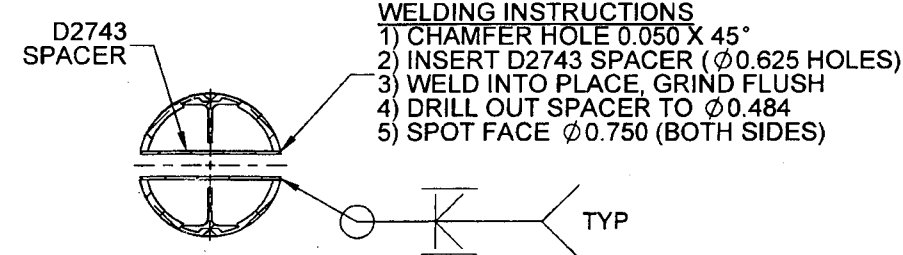
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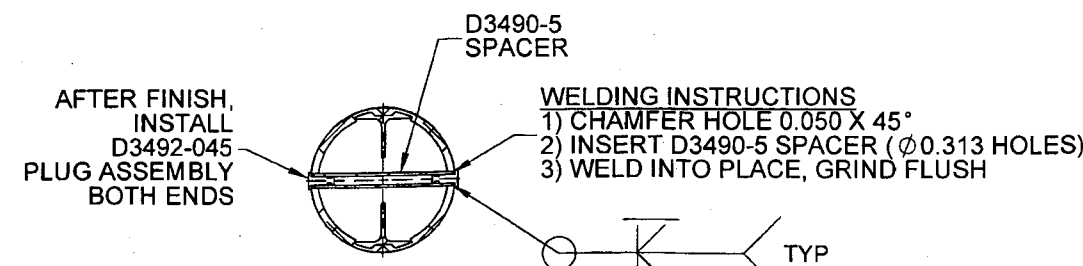
D2750-044 350 SKIDTUBE ASSEMBLY, RH



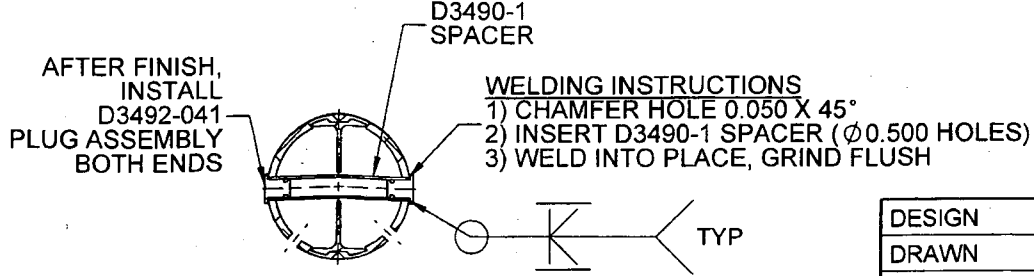
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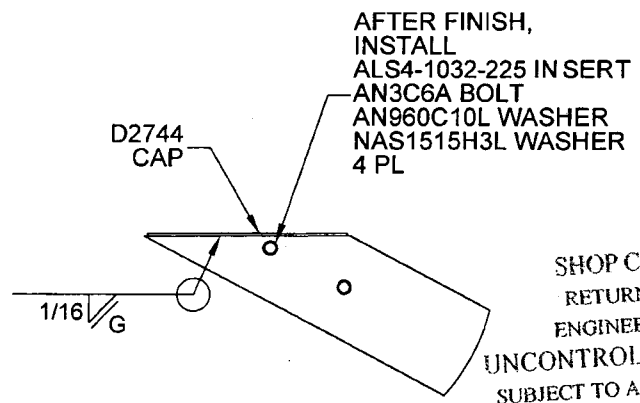
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(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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08.07.22 / M

AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL

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AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barchy Elliot
Job number: 2449
Part number: 1350-636-013
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[] DC[☒]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier David Smith Date of Test Coupon 08/10/20

Welder Barchy Elliot Date of Test Coupon 08/10/20

The above named individual is qualified in accordance with AWS D17.1.2001 to weld